







Date: Friday, 24/10/2008 3:32:07 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACK LEG FITTING
Job Number : 42958	
Estimate Number : 13293	
P.O. Number :	Part Number : D37641
This Issue : 24/10/2008 S.O. No. :	Drawing Number : D3764 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 40970	Material :
Written By : <u>J.F. 08.10.27</u>	Due Date : 03/11/2008 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 08-05-01 JLM Verified By:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6B1500X02000 6061-T6 Bar 1.50 x 2.00
	
Comment: Qty.: 0.2625 f(s)/Unit Total: 7.8750 f(s) 6061-T6 Bar 1.5 x 2.0 M108877X1 Batch: M18147	
2.0	BAND SAW BAND SAW
	
Comment: BAND SAW Cut blank 2.95" long	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
	
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA741 Rev: <u>B</u> & Dwg D3764Rev: <u>B</u> 2-Deburr per dwg D3764	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK	

R.F. 08/10/28

R.F. 08/10/28

PTO

M.A. 08/10/30

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3764-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 08.11.04

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42958</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.10.31</u>	<u>3.0</u>	<u>24 parts have the hole slightly enlarged on 1 side only on the Ø.323, +0.006; up to 0.004 over tolerance.</u> <u>R.C: Material build up in the drill flutes.</u>	<u>[Signature]</u> <u>DESIGN</u>	<u>parts acceptable in the ASS'y</u>	<u>H.A</u> <u>08/10/31</u>	<u>[Signature]</u> <u>08.11.04.</u>	<u>[Signature]</u> <u>08.11.04</u>	<u>[Signature]</u> <u>08.10.31</u>

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



30x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-J

08/11/03

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



us

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-03

30x

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 250

SS

08/11/03

30x

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

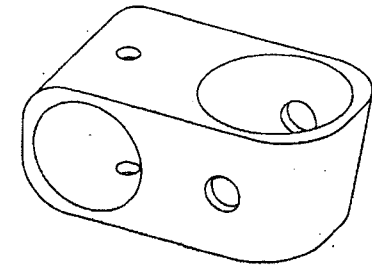
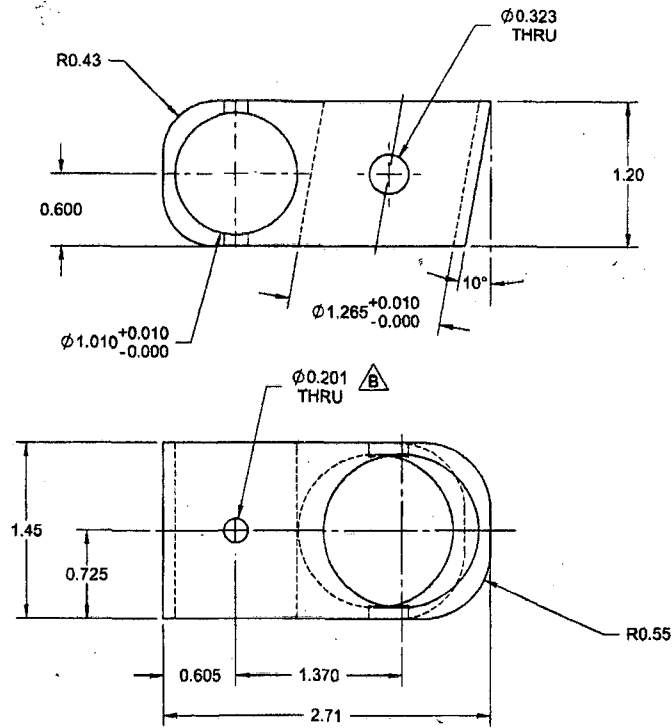
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

w/o 42958



D3764-1 BACK LEG FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

REV.	DESCRIPTION	BY	DATE
B	CHANGE HOLE SIZE TO 0.201	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3764	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	BACK LEG FITTING	NTS
DATE	08.06.10	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

